

# Work Order ID 53504

November 6, 2009 3:09:32 PM



Page 1

Item ID: D3262-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Tube

Start Date: 06/11/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals: Process Plan: PL Date: 07-11-06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3262	Rev C

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D3262-1 to length as per Dwg D3262  
Identify as D3262-1

*Cpl 09-11-16*  
*SL 09/11/16*

110



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Debur

*Cpl 09 11 16*

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

*W/g*

## November 6, 2009 3:09:32 PM



**Abstract**

**Stop**

**Abstract**

**Customer:**

**Required Date:** 13/11/2009      **Req'd Qty:** 8.00

**Reference:**

\_\_\_\_\_

**Stop**

**Abstract**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

Sorluks

05  
Memo

0.00

48

## Quality Control

0.00

## Memo

0.00

## Packaging

-2 cpl

0.00

## Memo

0.00

## Quality Control

09/11/17 A

mf  
09-11-17

# Picklist Print

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Page 1

Work Order ID: 53504

Parent Item: D3262-1RevC

Parent Item Name: Tube

Comments: IPP RevD: revC as per dwg 09.11.06 DD verified by:JLM

Start Date: 06/11/2009

Required Date: 13/11/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6T5.000W.125

Purchased

No

f

20.7400

7.5200



6061-T6 Tube 5.00 X.125W

*Cpl 09.11.16*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

20.74

102019

5.24

105532

3.5

111699

12

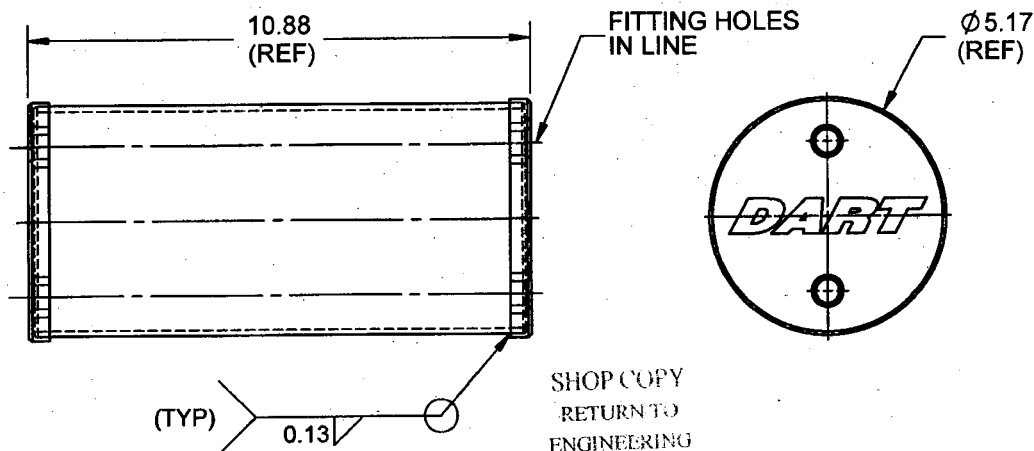
*70.5 ~~5.25~~ 6.94 ✓*

*70.5 ~~5.25~~ 6.58*



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3262</b>	REV. C SHEET 1 OF 2
DATE <b>06.08.31</b>	TITLE <b>FUEL PURGE CANISTER</b>		SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.05.06	FIRST ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	
C	06.08.31	Ø5.165 WAS Ø5.190	

RELEASED  
06.09.19 *[Signature]*



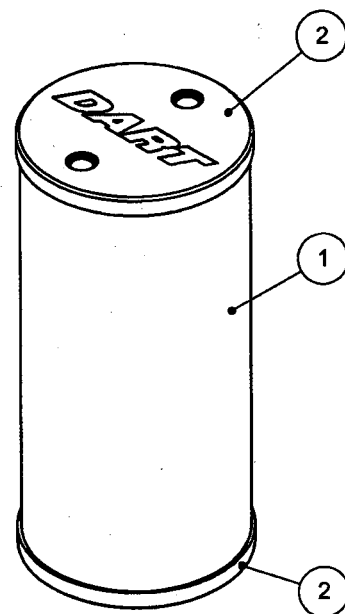
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *53504*  
*PH 0911-4*

### D3262-041 CANISTER ASSEMBLY

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3362-041	CANISTER ASSEMBLY
1	1	D3262-1	TUBE
2	2	D3262-3	CAP

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER

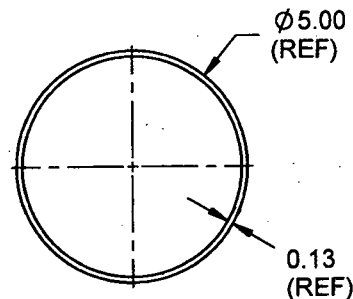
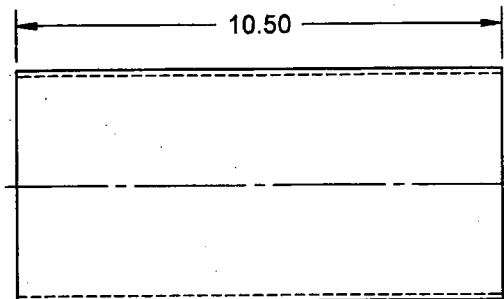


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**DART**

DESIGN <i>PH</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3262</b>	SHEET 2 OF 2
DATE <b>06.08.31</b>	TITLE <b>FUEL PURGE CANISTER</b>	SCALE 1:4	

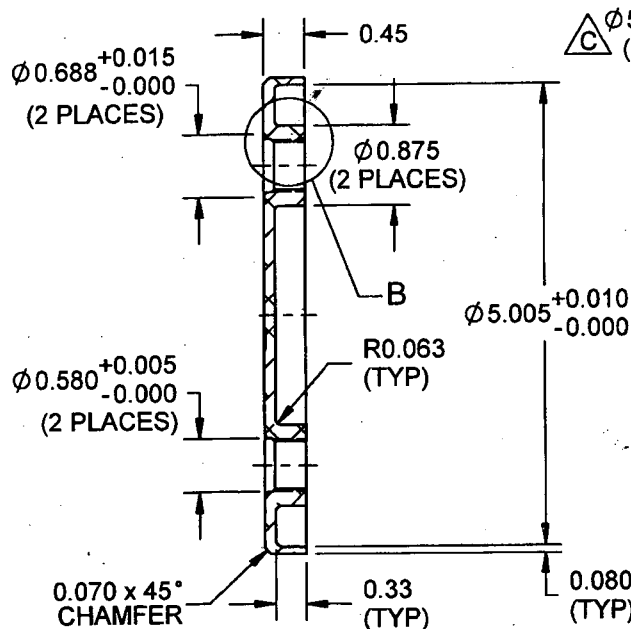
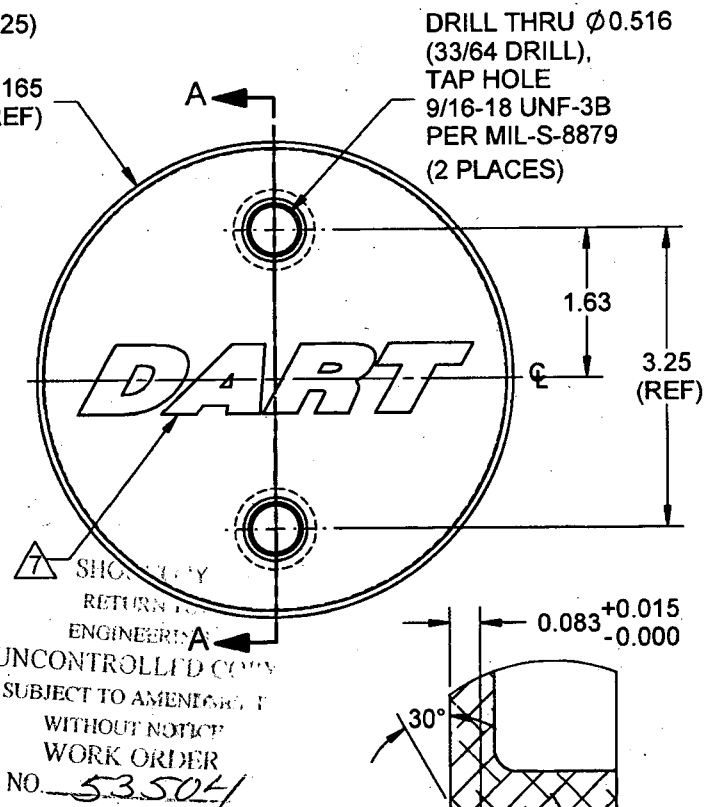


RELEASED

06.09.11

**D3262-1 TUBE**

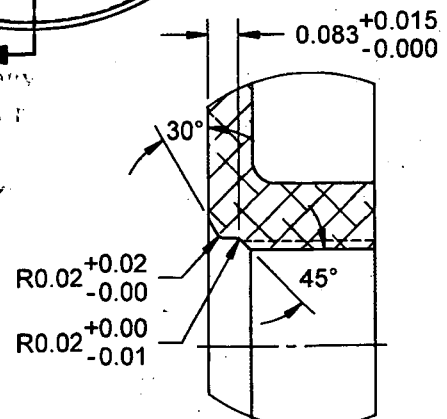
- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL  
PER VW-T-700/6 OR AMS 4080 OR AMS 4082 OR  
QQ-A-200/8 OR QQ-A-225/8  
(REF. DART SPEC. M6061T6T5.000W.125)

**SECTION A-A**  
SCALE 1:2**D3262-3 CAP**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF. DART SPEC. M6061T6B)

**NOTES:**

- FINISH: NONE
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- BREAK ALL SHARP CORNERS 0.005 TO 0.010
- PART IS SYMMETRICAL ABOUT CENTERLINE
- ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

**DETAIL B**  
SCALE 2:1

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